



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-3-6**Job Sheet 192150****Part No:** C45-3-6**Job Qty:** 12 pcs**Part Name:** Latch**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/18/19**Job Tracking No:****Due Date:** 4/26/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** C45-3-6 rev.10 IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	4/26/19	4/26/19	0.00	0.60	Bandsaw - 1		JSD 19/3/25
120	NV5000 - 1 - B4B	12 pcs	4/26/19	4/26/19	0.00	6.00	NV5000 - 1 - B4B		" "
							NV5000 - 2 - B4B		PT 19-03-31
130	QC 2	12 pcs	4/26/19	4/26/19	0.00	0.00	QC 2 - 1		PT 19-03-31
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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140 QC 8	12 pcs	4/26/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	11 11
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B.e 19-04-06
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
150 Packaging 3-2 - Stock - B4B	12 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

3/18/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

160 QC 21 - FG	12 pcs	4/26/19	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - FG - 21	DAG
				QC 21 - FG - 70	21 APR 08 2019
				QC 21 - SA - 53	9-88

Part Op 100 - (Bandsaw) CUT BLANK AT 1.825"

Descriptions: 120 - (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FB814 FOLIO REV: AA DWG REV:10 2-Debur

130 - (QC2- Inspect parts off machine FAI/FAIB) 1-Engrave Batch number as required Using Marktronic engraver as per DWG.

140 - (QC8- Inspect parts - second check)

150 - Identify as per dwg & Stock Location: _____) Identify and Stock

160 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	1.9999 ft (.16666 ea)	100-Bandsaw - 1	<u>5/58304</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B1.250X2.000	2	25	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	192150
Description:		Part Number:	C45-3-6
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.715	$\pm .005$	.715	✓		Vern	
.375	$\pm .005$	.375	✓		"	
.170	$\pm .005$	.168	✓		"	
.30	$\pm .000$	.300	✓		"	
63°	$\pm 1/2^\circ$	63°	✓		C-Aperture	
.766	$\pm .005$	.766	✓		Vern	
1.05	$\pm .000$	1.057	✓			
.26	$\pm .010$	.260	✓			
.115	$\pm .005$	.115	✓			
.02	$\pm .010$	.020	✓			
44°	$\pm 1/2^\circ$	44°	✓		C-Aperture	
R.41	$\pm .010$	R.410	✓		R-6	
14°	$\pm 1/2^\circ$	14°	✓		C-Aperture	
1.33	$\pm .010$	1.331	✓		Vern	
.920	$\pm .005$	.920	✓			
.80	$\pm .010$	.800	✓			
.44	$\pm .010$	.446	✓			
Ø.566	$\pm .001$	Ø.566	✓			
.480	$\pm .005$	.476	✓			
.468	$\pm .003$	.468	✓			
.188	$\pm .005$	.188	✓			
.140	$\pm .005$	.137	✓			
.124	$\pm .005$	.124	✓			
R.03	$\pm .000$	R.030	✓		R-6	
1.50	$\pm .010$	1.500	✓		Vern	
Ø.191	$\pm .005$	Ø.193	✓		"	
Ø.376	$\pm .003$	Ø.3775	✓		"	
.625	$\pm .005$	.625	✓		"	
.048	$\pm .005$	.048	✓		"	

Measured by:	PJ/ank	Checked by:	B.e	QC Inspector:	
Date:	19-03-31	Date:	19-04-06	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

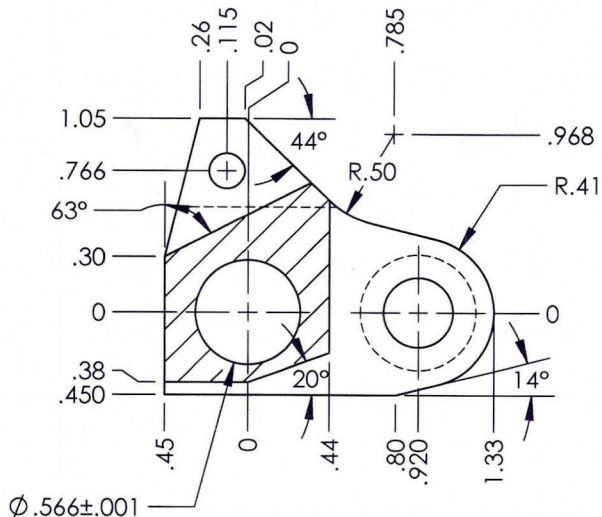
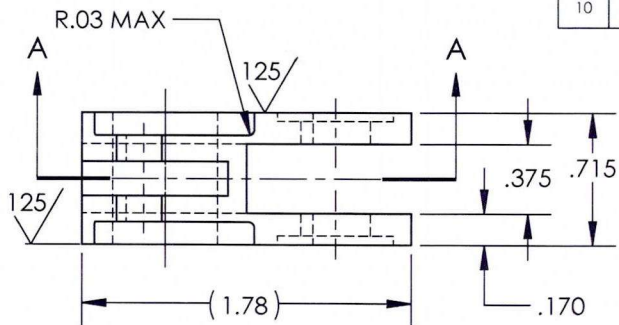
NCR No. _____

Route update only ☐

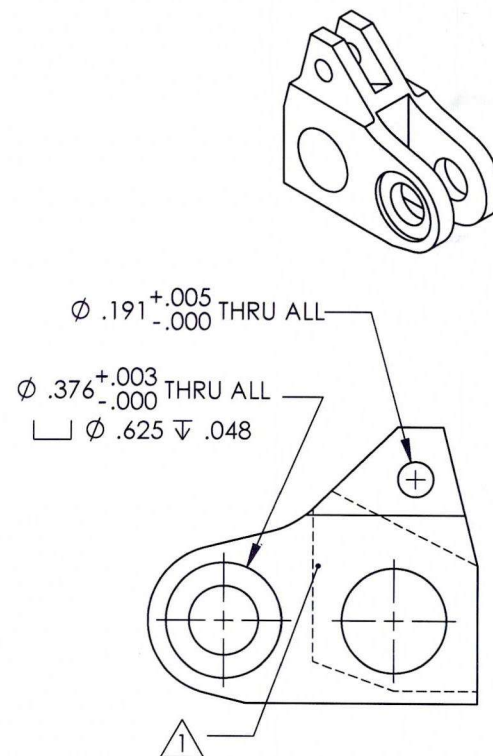
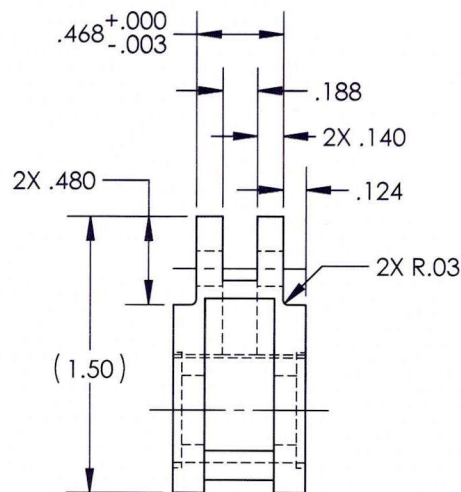
Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details: _____					

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
8		AS DRAWN BY CANAM.		9/11/2012	RJC	
9		CH'D Ø.564 TO Ø.566 & Ø.189 TO Ø.191		10/30/2012	JAG	
10	14-0126	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.		8/13/2014	DPD	RW



SECTION A-A



NOTE:

1 MACHINE ENGRAVE BATCH NUMBER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19215045
(9-03-18)

DART AEROSPACE	
TITLE LATCH	
DWG NO. C45-3-6	REV 10
MATL 17-4 SS	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D West</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	FINISH
SCALE 1:1	DATE 5/14/1997
USED ON MODEL	
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-3-6	1	LATCH	17-4 SS	3/4 X 1-1/2 X 2



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S165726



Part: C45-3-6

Job No: 192150

Serial No/Batch: S165726

Revision: 10

Inspector:

Exp Date:

Instructions:

Date: 03/25/19